



Dart Aerospace Ltd.
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D3183-9
Job Sheet 178580



Part No: D3183-9

Job Qty: 50 ea

Part Name: Cap



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/4/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP A 06.05.03 New issue KJ

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		6/15/18	0.00	0.00	Start Up Machining-2	2 min L	JB 18.06.04
100	Hardinge	50 pcs		6/15/18	0.05	2.63	Hardinge	"	JB 18.06.04
120	QC	50 pcs		6/15/18	0.00	0.00	QC8		JB 18.06.07
130	Packaging	50 pcs		6/15/18	0.00	0.00	Packaging3-1	JUN 08 2018	
140	QC21-SA	50 Ea		6/15/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - Turn D3183-9 Cap as per Folio FA388

DAS
21
9-06

JUN 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELINR1.000	Delrin Round Bar 1" Color: Black	1.6650 ft (.0333 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MDELINR1.000	2	17	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cap	0.830inches ± 0.005	0.835 0.825		
2	Cap	0.720inches ± 0.002	0.722 0.718		
3	Cap	0.747inches ± 0.001	0.748 0.746		
4	Cap	0.010inches ± 0.010	0.020 0.000		
5	Cap	0.0311inches ± 0.0100	0.0411 0.0211		
6	Cap	0.199inches ± 0.001	0.200 0.198		
7	Cap	0.276inches ± 0.010	0.286 0.266		
8	Cap	0.039inches ± 0.010	0.049		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
			Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
			Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
			Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause	
Environment ☐	No Re-ve. ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Set. ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Test ☐
Internal Transport ☐	Poor Inform. ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Impro ☐
Substation ☐	Process Impro ☐
Past Expiry Date ☐	Manufacturing ☐
Misidentified ☐	Past Due ☐

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Container No: S077837



Part: D3183-9

Job No: 178580

Serial No/Batch: S077837

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/04/18

Date: 06/04/2018

/Surge	☐	Positioned Wrong
am	☐	Outside Dimensions
	☐	Over/Under tolerance
	☐	Part Incorrect
Pulled	☐	Part Lost/Missing
nce	☐	Part Moved
	☐	Drawing
	☐	Finish
	☐	Misread
center	☐	Turning Sequence